

Date: Wednesday, 3/8/2006 10:35:31 AM
 User: Kim Johnston

Process Sheet

15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH
 Job Number : 26101
 Estimate Number : 10268
 P.O. Number : N/A Part Number : D350636014
 This Issue : 3/8/2006 S.O. No. : N/A Drawing Number : D2750 REV C1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C1
 Previous Run : 25514 Material : N/A
 Due Date : 4/15/2006 Qty: 1 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : KA 06.03.08
 Comment : Est Rev:H 02.09.25 Rearranged procedure steps KJ
 Est Rev:H 05.12.08 Rearranged procedure steps EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 001

DIT 06/03/21 1

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent) B25384 Pm 06-03-09①

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2744 Cap B24672 BE 06-04-18①

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end Pm 06-03-09①

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330 Pm 06-03-09①

*****Drill last hole using Dt 8820 locating off last hole drilled*****

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO Pm 06-04-18①
 9133 Do not open any 0.625" AE holes to finished size

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Wednesday, 3/8/2006 10:35:32 AM
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 26101

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes as per Dwg D2750 (Sheet 3 ,D2750-4),mark Fwd end for cutting using Drill Jig DT8150,then drill both sides.

5-Open holes as per detail "P" To 500",then Drill pilot holes to detail "B" using DT8330
Make sure that wearplate holes are on bottom of tube**

6-Open holes to .500" as per detail "B&C".

7-Open holes to .375"mas per detail "D"

8-Cut fwd end of tube as per Dwg D2750

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail A

10-Open holes to .391" as per detail "D".

11-Deburr

12-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *ml 9/01* *BE 06-04-18*

13-Grind welds flush as per Dwg D2750
BE 06-04-19

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

BE 06-04-14 / BE 06-04-19

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BE 06-04-19

7.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2739 Web

326385

BE 06-04-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 26101

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit - Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 D2743 Crossbolt spacer

B-25838 BE 06-04-25 (1)

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" AE holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil

pm 06-04-25 (1)

2-Deburr and blow out all chips from inside of tube

pm 06-04-20 (1)

3-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

M100180

Sikaflex expire date: 06-11-01

pm 06-04-20 (1)

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004

A/R Aluminum Rod

M19101 BE 06-04-25 (1)

5-Grind welds flush as per Dwg D2750

pm 06-04-26 (1)

6-Spot face ground handling holes AE0.750" (8 places)

pm 06-04-26 (1)

7-Deburr holes

pm 06-04-26 (1)

10.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

PD 06-04-26

pm 06-04-26 (1)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

DC 06/05/01 (1)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

FC 06 05 01 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 26101

Part Number: D350636014

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 D27422 Blade Fitting, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2742-2	Blade Fitting, RH	B 24640 ✓

14.0 AN835A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	M18576 ✓

15.0 AN960JD816 1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956 ✓

16.0 MS21083N8 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	M19185 ✓

17.0 D26483 Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	B 2443-2 ✓

18.0 D265613 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	B 25329 ✓

9-m 06-05-01 (1)

Dart Aerospace Ltd

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Job Number: 26101

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	D265635	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearplate	B 25330 ✓

20.0	D2746	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2746	Wearplate	B 24149 ✓

21.0	ALS41032225	Insert
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Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	ALS4-1032-225	Insert	M 15293 ✓
(or AKS4-1032-225)			
(or ALS7-1032-225)			
(or AKS7-1032-225)			

130

am 06-05-01

(1)

22.0	AN960JD10L	Washer
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Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
42	AN960JD10L	Washer	M 19185 ✓

23.0	AN35A	Bolt
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-5A	Bolt	M 15205 ✓

am 06-05-01

(1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 26101

Part Number: D350636014

Job Number:



Seq. #: Machine Or Operation: Description :

24.0 AN36A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M100274

25.0 D2745 Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D2745	Bushing	B-5840

26.0 AN644A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN6-44A	Bolt	M18369

27.0 MS21042L6 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	M17614

28.0 AN36A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M100274

a.m 06-05-01 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 26101

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
4 AN960JD10 Washer

Batch M16066
~~24 M 17185~~

a.m. 06-05-01

②

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.

A/R Sikaflex-291 M100480

Sikaflex expire date: 06-11-06

a.m. 06-05-01

①

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.

A/R Sikaflex-291 M100480

Sikaflex expire date: 06-11-06

a.m. 06-05-01

①

3-Install D2745 Bushing as per Dwg. D2750 Detail M

4-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

a.m. 06-05-01

①

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

TC 06 05 02 ①

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

33.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Kit Picking

Qty Part Number Description
1 D2741 Blade

Batch B24750 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 26101

Part Number: D350636014

Job Number:



Seq. #: Machine Or Operation: Description :

34.0 AN960JD816 1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956

35.0 MS21083N8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty	Part Number	Description	Batch
2	MS21083N8	Nut	M19099

36.0 AN816A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty	Part Number	Description	Batch
2	AN8-16A	Bolt	M5760

SP 06/05/02

37.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/05/02 (1)

38.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

REV 0 06/05/02 (1)

39.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/03 (1)

Job Completion



u 06/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DH</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>DH</i>	APPROVED <i>KE</i>	DRAWING NO. D2750	REV. C SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
CI	<i>CP</i> 05.01.20	CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED	

RELEASED
98.12.16 DS

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
40	40	40	40	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
44	44	44	44	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
44 42	44 42	44 42	44 42	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

DEO 4133 DS 98.01.19 DS	DEO 4137 98.10.21 DS
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EFFECTIVE , DEOS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26101



DESIGN <i>DA</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>DA</i>	APPROVED <i>KE</i>	DRAWING NO. D2750	REV. C SHEET 2 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

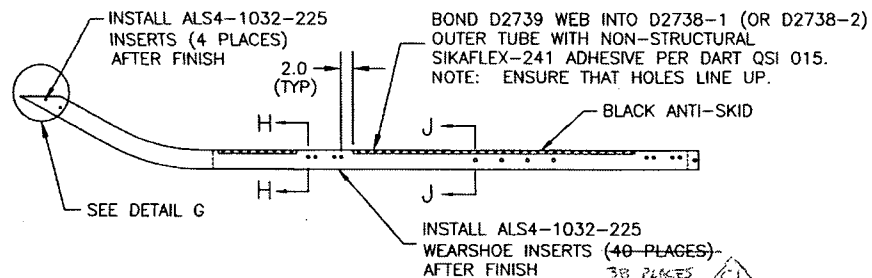
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

EFFECTIVE	DEOs
DEO 9133 98.01.19 DS	DEO 9157 99.10.21 DS

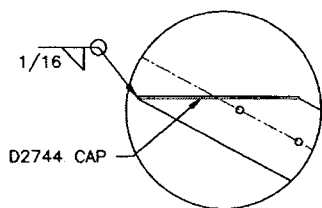
RELEASED
99.12.16 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

D2750-1/-2/-3/-4 WELDING DETAIL
(FLOAT ATTACHMENT HOLES REMOVED)
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)



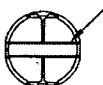
DETAIL G



SECTION H-H

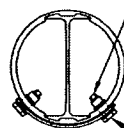


SECTION J-J



- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2743 SPACER
 3. WELD INTO PLACE
 4. GRIND FLUSH
 5. DRILL OUT SPACER TO Ø0.484
 6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

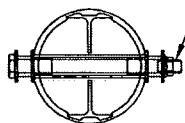
DETAIL K



USE AN3-6A BOLTS FOR INSTALLING AFT D2648-3 WEARPAD

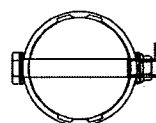
AN3-5A BOLT (1)
AN960JD10L WASHER (1)
(44 PLACES)
(42 PLACES)

DETAIL M



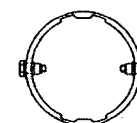
AN6-44A BOLT (1)
D2745 BUSHING (2)
MS21042L6 NUT (1)
(4 PLACES)

DETAIL P



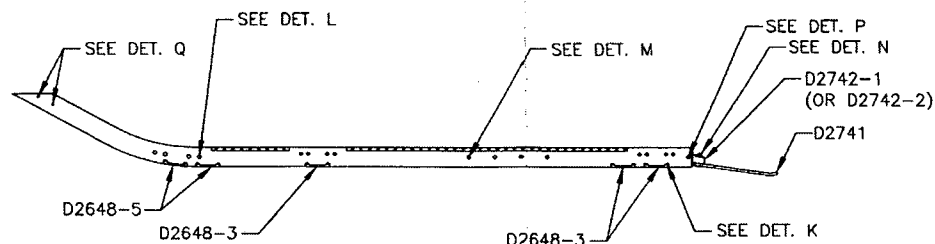
AN8-35A BOLT (1)
AN960JD816 WASHER (2)
MS21083N8 NUT (1)

DETAIL Q

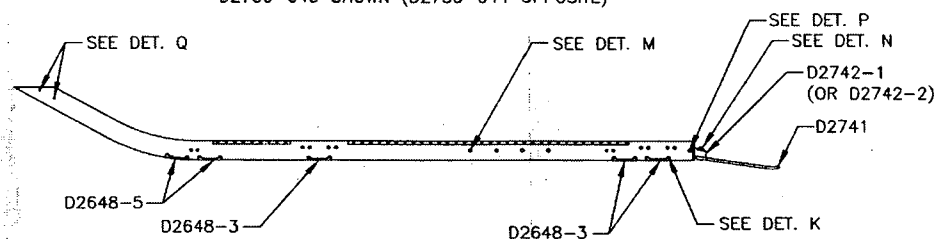


AN3-6A BOLT (1)
AN960JD10 WASHER (1)
(4 PLACES)

D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)



D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)



RELEASED
98.12.16 DS

EFFECTIVE	DEOs
DES 9133 98.01.19 DS	DES 9157 99.10.21 DS

DESIGN #	DRAWN BY CP	DART DART AEROSPACE USA, INC. BELLEVUE, WA	REV. C
CHECKED #	APPROVED KE	DRAWING NO. D2750	SHEET 4 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20

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